

Work Order ID 78317

78317

Page 1

January-05-12 8:33:40 AM

Item ID: D206-781-151KGY

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vertical Tunnel-Grey

Start Date: 05/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/01/05

Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr

100 0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-781-151KGY (CHG 001)

8/12/02/02

MLJ 12-2-8

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

12/1/8

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.00

Quality Control

8/12/02/02

(+U)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop ***NS2***

Item Name: Vertical Tunnel-Grey

Start Date: 05/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-781-151KGY

Location: _____

PPP rev

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/2/8 SP

12/2/8 JG

MF
12-02-08

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 78317

78317

Parent Item: D206-781-151KGY

D206-781-151KGY

Parent Item Name: Vertical Tunnel-Grey

Start Date: 05/01/2012

Required Date: 19/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4632-130

Purchased

No

110

Each

993.0000

8

8

**

AI S4632-130

insert

Location

Loc Qty

Loc Code

ST282

993

118908

993

ALS4-632-80

Purchased

No

110

Each

172.0000

4

4

**

AI S4-632-80

Insert

Location

Loc Qty

Loc Code

ST282

172

112495

172

D3800-1-100

Manufactured

No

110

f

54.6430

1.33

1.33

**

D3800-1-100

Hook and Loop Strip (1" Soft)

Location

Loc Qty

Loc Code

ST084

54.643

68910

9.801

72233

9.841

73645

10

75104

25.001

(D3800-1-100-800) cut (2) at 80.00" per kit

measured
S212/00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-781-151KGY

D206-781-151KGY

Parent Item Name: Vertical Tunnel-Grey

Start Date: 05/01/2012

Required Date: 19/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3800-3-100

Manufactured No

110 f

85.6430

1.33

1.33 13.3

D3800-3-100

Hook and Loop Strip (1" Hard)

**

Location

Loc Qty

Loc Code

ST084

85.643

68915

18.301

72771

2.341

73007

15.001

75105

50

(D3800-3-100-800) cut (2) at 80.00" per kit

D3822-1KGY

Manufactured No

110 Each

2.0000

**

D3822-1KGY

Vertical Tunnel, LH-Grey

Location

Loc Qty

Loc Code

ST152

2

73912

2

D3822-2KGY

Manufactured No

110 Each

2.0000

**

D3822-2KGY

Vertical Tunnel, RH-Grey

Location

Loc Qty

Loc Code

ST152

2

73910

2

D3822-3KGY

Manufactured No

110 Each

2.0000

**

D3822-3KGY

Vertical Tunnel, Aft Center-Grey

Location

Loc Qty

Loc Code

ST156

2

73914

2

January-05-12 8:33:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 78317

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Parent Item: D206-781-151KGY

D206-781-151KGY

Parent Item Name: Vertical Tunnel-Grey

Start Date: 05/01/2012

Required Date: 19/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3822-5KGY

Manufactured No

110 Each

2.0000

**

D3822-5KGY

Vertical Tunnel, Top-Grey

Location

Loc Qty

Loc Code

ST150

2

73911

2

D3822-7KGY

Manufactured No

110 Each

2.0000

**

D3822-7KGY

Vertical Tunnel, Lower-Grey

Location

Loc Qty

Loc Code

ST150

2

73913

2

NAS388-6-12P

Purchased No

110 Each

28.0000

**

NAS388-6-12P

Screw

Location

Loc Qty

Loc Code

ST278

28

116523

28

NAS388-6-8P

Purchased No

110 Each

133.0000

**

NAS388-6-8P

Screw

Location

Loc Qty

Loc Code

ST278

133

116416

33

119673

50

119716

50

January-05-12 8:33:44 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-781-151KGY

D206-781-151KGY

Parent Item Name: Vertical Tunnel-Grey

Start Date: 05/01/2012

Required Date: 19/01/2012

Start Qty: 1.00

Required Qty: 1.00

NAS391B6P

Purchased

No

110

Each

178.0000

18

18

**

12/2/05

NAS391R6P

Washer

Location

Loc Qty

Loc Code

ST278

178

116416

2

~~118840~~

76

118891

100

18

January-05-12 8:33:44 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D407-781-3

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5.2 D206-781-141/-143/-151/-161/-171/-173/-191/-193 KITS

Qty -141	Qty -143	Qty -151	Qty -161	Qty -171	Qty -173	Qty -191	Qty -193	Part Number	Description
X								D206-781-141	CREW CABIN OVERHEAD W/O ROTOR BRAKE KIT
	X							D206-781-143	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
		X						D206-781-151	VERTICAL TUNNEL KIT
			X					D206-781-161	REAR OVERHEAD KIT
				X				D206-781-171	HAT BIN KIT
					X			D206-781-173	HAT BIN KIT, LITTER KIT COMPATIBLE
						X		D206-781-191	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
							X	D206-781-193	ROTOR BRAKE PANEL KIT
1								D3821-1	PANEL - W/O ROTOR BRAKE
	1							D3821-3	PANEL - W/ ROTOR BRAKE
4	4							NAS388-6-8P	SCREW
4	4							NAS391B6P	WASHER
		1						D3822-1	VERTICAL TUNNEL, LH
		1						D3822-2	VERTICAL TUNNEL, RH
		1						D3822-3	VERTICAL TUNNEL, AFT CENTER
		1						D3822-5	VERTICAL TUNNEL, TOP
		1						D3822-7	VERTICAL TUNNEL, LOWER
	2							D3800-1-100-800	LOOP STRIP
	2							D3800-3-100-800	HOOK STRIP
	4							NAS388-6-8P	SCREW
	14							NAS388-6-12P	SCREW
	18							NAS391B6P	WASHER
	4							ALS4-632-80	INSERT
	8							ALS4-632-130	INSERT
			1					D3823-1	REAR OVERHEAD, LH
			1					D3823-2	REAR OVERHEAD, RH
			1					D3823-3	REAR OVERHEAD, CENTER
			10					AN525-10R24	SCREW
			10					NAS43DD3-68	SPACER
				1				D3824-1	HAT BIN
					1			D3824-3	HAT BIN
				6	6			D3851-1	DOUBLER
				4	4			AN525-10R10	SCREW
						1		D4077-1	OVERHEAD PANEL, LH
						1		D4077-2	OVERHEAD PANEL, RH
							1	D4118-1	ROTOR BRAKE PANEL
						1		D4119-1	PANEL
						6		NAS388-6-8P	SCREW
							4	NAS388-6-12P	SCREW
						6	4	NAS391B6P	WASHER
							4	MS21059L06	NUTPLATE
							8	MS20426AD3-3	RIVET

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Revision: A

Date: 10.10.28